

DART AEROSPACE LTD	Work Order:	18433
Description: Door Assembly	Part Number:	D412-694-01 D412-694-03
Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	Qty:	1
		Page 1 of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D412-694-01-03 D3140-5-7 Door Assembly Doubler Kit		03.03.10	1
2	PG	Issue P/O: Description: D3140-05-07 D3119-041-042 Door Cover Assembly Supplier: Delastek Ship to Delastek Qty Part Number Description Batch		SEE ATTACHED 03.03.10	
3	RG	Receive D3140-05-07 Door and D3119-041-042 Cover Assembly. Inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.			
4	QC3	Visual inspection. Check for void spot and pins. Check over all dimensions and windows as per Dwg D3140.			
5	CA	Drill Pilot hole Ø(#40) using B30-23000-1A as per Dwg D412-694 page 4 (view P). Open (1) hole to 11/16" (0.688) for the handle	ml	03-09-08	1
6	CA	Drill Pilot holes Ø(#30) using drill Jig D3144-T1, and mark slot for the slot opening. Cut slot in (2) places per mark as per Dwg D412-694 page 4 (view P) and page 2.	ml Router	03-09-22	1
7	CA	Drill (4) pilot holes Ø(#30) for D3151-041 doubler assembly and (12) holes Ø(#30) for D3162-041 bracket using drill Jig D3162-041T1 as per Dwg D412-694 page 4 (view P).	ml	03-10-20 3.10.15	1
8	CA	Open (3) holes to Ø 19/32" (0.593) at top and (3) at bottom for insert as per Dwg D412-694 page 4 (view P).	ml	03-09-10	1
9	CA	Drill Pilot holes Ø(#30) for rollers using drill Jig DT8703-1A. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q). Q - X - L - M	ml	03-09-08	1
10	CA	Drill Pilot holes Ø(#30) for rollers using drill Jig DT8703-1B. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).	ml	03-09-10	1
11	CA	Drill (27) pilot holes Ø(#30) using drill Jig B30-23000-211LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Open holes Ø 19/32 (0.593) for insert.	ml	03-09-10	1
12	CA	Open Ø(#19) and C-sink Ø 0.332 x 100° from the far side (3) holes for each D3155-041-042 bracket assembly as per D412-694 page 4 (view P).	ml	03-10-17	1
13	QC5	Inspect work to Step 12	RF	03-12-18	1
14	CA	Place D412-694-01 and D412-694-03 in the mold DT N/A RT. Trace slots from the big door to the small door. Ensure proper alignment.	ml	03-10-15	1
15	CA	Remove both doors from the mold.	ml	03-10-15	1
16	CA	Drill pilot holes Ø(#30) using drill Jig D3144-T3. Ensure slot is aligned with mark as per Dwg D412-694 page 3.	RF	03-10-15	1
17	CA	Open slot as per mark.	ml	03-10-15	1
18	CA	Open (4) holes Ø 0.191" for D3150 guide as per Dwg D412-694 page 5 (view CC and DD)	ml	03-11-17	1
19	CA	Drill pilot holes for cover Ø(#30) using drill Jig D3119-041T3A, D3119-041T3B and D3119-041T3C holding the Jig by cleco using hole from step 16. Open holes for the cover to Ø 20/64 (0.433) for inserts as per Dwg D412-694 page 3.	ml	03-11-25	1

Preliminary

ISSUE

Bracelet OSCE update PTO

Step 5
Step 9
do not pass thru it for insert

Roller Bracket Update

①

update Roller brackets as
per DSF 9274

exchange

D3212-241 B20779

D3183-05 B~~20430~~²⁰⁵⁹³

D3183-7 B20430

D3121-21 B20778 B

B

01-10-27

②

exchange D3121-044

Ser D3121-041

18#

B

01-10-27

A
See W/O 21 819

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Step	Location	Procedure	By	Date	Qty
20	CA	Drill (4) pilot holes Ø(#30) using drill Jig D3111-041T3 as per Dwg D412-694 page 5 (view W). Open holes to Ø 0.193-0.197 and c'sink Ø 0.385 x 100° from the far side of the door for D3111-041 plate assembly.	ml	03-10-23	1
21	CA	Drill pilot holes Ø(#30) using drill Jig D3120-3T3 for bottom cover. and D3120-1T1 for top cover. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 3	ml	03-10-23	1
22	CA	Drill pilot holes Ø(#30) using drill Jig D3146-T1 for hinges. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 3, page 4 (view MM-MM)	ml	03-10-23	1
23	CA	Drill pilot holes Ø(#30) using drill Jig D3142-041T3 for window.	N/A		PTF 03-12-18
24	CA	Drill through hole Ø 5/8 (0.625) and pilot drill Ø (#30) using drill Jig D3112-1T3A for the top. Open holes to Ø 19/32 (0.593) for clevis inserts at top as per Dwg D412-694 page 5 (section AA-AA)	ml	03-11-03	1
25	CA	Drill through hole Ø 5/8 (0.625) and pilot drill Ø (#30) using drill Jig D3112-1T3B for clevis insert at bottom. Open holes to Ø 19/32 (0.593) for clevis inserts at top as per Dwg D412-694 page 5 (section AA-AA)	ml	03-11-03	1
26	CA	Router slot for D3112-1 guide using tool D3112-1T3C at bottom as per Dwg D412-694 page 5 (section AA-AA). 0.210" deep	ml	03-11-03	1
27A	CA	Router slot for D3112-1 guide using tool D3112-1T3D at top as per Dwg D412-694 page 5 (section AA-AA). 0.210" deep	ml	03-11-03	1
28	CA	Drill pilot holes Ø(#30) for D3114 pivot using drill Jig D3114-1T3. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 4 (view MM-MM)	ml	03-11-03	1
29	CA	Drill (1) Ø(#10) 0.193 for clevis base at top and (2) Ø(#19) 0.166 for stop using drill Jig D3130-1T3 as per Dwg D412-694 page 5 (section FF-FF)	ml	03-10-29	1
30	CA	Drill Ø(#10) 0.193 for clevis base at bottom as per Dwg D412-694 page 5 (section FF-FF)	ml	03-10-29	1
31	QC5	Inspect work to Step 30	PTF	03-12-18	1
32	CA	Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, K, L, M, Q). Pick: (for D412-694-01) Qty Part Number Description Batch 65 80-005-2-8 Insert M11762 12 129781700 Epoest-50A M13770-M12962 Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). Pick: (for D412-694-03) Qty Part Number Description Batch 21 80-005-2-8 Insert M11762 12 SL607-06-9S Insert N/A 12 129781700 Epoest-50A M13770-M12962		03-11-26	1
33	CA	Install D3162-041 as per Dwg D412-694 page 4 (view R-R and S-S) and D3156-1 bracket as per (view T-T and U-U). Pick: Qty Part Number Description Batch 2 D3156-1 Bracket M10536-17 12 D3162-041 Bracket Assembly B17445 12 M7885/2-4-3 Rivet M6733 16 MS20426AD4-7 Rivet M12655	ml	03-10-17	1

PRELIMINARY ISSUE PTO

Step 35: Scrap 1x3116-5 -0680 and

27B	CA	(2) Shear blanks 0.650" x 2.650" Material: 2024-T3 (QQ-A-250/4) 0.040" thick	RF	03-10-25	2
27C	WA	Tag spot point on three location for guide the plate Deburr. spot point high. 0.030"	M	03/10/25	2
27D	FP	Chemical conversion as per QSI 005 4.1	J	03-10-25	2
27E	CA	Install plate with Hysol EA934NA fill slot leave Bond 0.050" from top surface. Note Top and bottom			
		AE Hysol EA934NA		Batch: M13770 - M12962	
		Batch: M13770			
		Router D3112-1 guide to the depth 0.150. from the top surface	ML	03-11-7	2
27F	CA	check with D3112-1 to fit	ML	03-11-14	2
		328			

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34	CA	<p>Install Doubler as per Dwg D412-694 page 4 (view P)</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>1</td><td>D3151-041</td><td>Doubler</td><td>M10536-17</td></tr> <tr> <td>4</td><td>MS20426AD4-6</td><td>Rivet</td><td>M2566</td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3151-041	Doubler	M10536-17	4	MS20426AD4-6	Rivet	M2566		03-10-02	1																																																																																													
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35	CA	<p>D412-694-01 Installation</p> <p>Install Doublers to door as per Dwg D412-694 page 2 (section V-V). Bond D3116-7-0680 Seal with 1440B-1/2 Sealant as per Dwg D412-694 page 2 (view V-V and N). Transfer slot opening in the seal.</p> <p>Pick: BSP 46</p> <table> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>1</td><td>D3116-7-0680</td><td>Seal</td><td>B17462</td></tr> <tr> <td>1</td><td>D3144-3</td><td>Doubler</td><td>B18816</td></tr> <tr> <td>1</td><td>D3144-8109</td><td>Doubler</td><td>M10090 → M10090</td></tr> <tr> <td>1</td><td>D3144-11111</td><td>Doubler</td><td>M10090 → M10080</td></tr> <tr> <td>1</td><td>BSP45</td><td>Rivet</td><td>M11201</td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3116-7-0680	Seal	B17462	1	D3144-3	Doubler	B18816	1	D3144-8109	Doubler	M10090 → M10090	1	D3144-11111	Doubler	M10090 → M10080	1	BSP45	Rivet	M11201		03-10-02	1																																																																																	
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36	CA	<p>Assemble D3123-1 Cam with D3124-1/-2 Hook and Rod Weldment. Install D3155-041/-042 Assembly. Connect Rod Weldments to D3122-1 Lever and D3127-1 Spacer. Install D3141-1 Spring as per Dwg D412-694 page 4 (view P).</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>1</td><td>D3122-1 ✓</td><td>Lever</td><td>M10536-17</td></tr> <tr> <td>2</td><td>D3123-1 ✓</td><td>Cam</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3124-1 ✓</td><td>Hook</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3124-2 ✓</td><td>Hook</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3127-1 ✓</td><td>Spacer</td><td>B17784</td></tr> <tr> <td>1</td><td>D3132-041 ✓</td><td>Rod Weldment</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3133-041 ✓ 042</td><td>Rod Weldment</td><td>M10536-17</td></tr> <tr> <td>2</td><td>D3141-1 ✓</td><td>Spring</td><td>B18638</td></tr> <tr> <td>2</td><td>D3148-1 ✓</td><td>Clevis</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3155-041 ✓</td><td>Bracket Assembly</td><td>M10536-17</td></tr> <tr> <td>1</td><td>D3155-042 ✓</td><td>Bracket Assembly</td><td>M10536-17</td></tr> <tr> <td>4</td><td>AN960JD10L ✓</td><td>Washer</td><td>M12749</td></tr> <tr> <td>2</td><td>AN960JD416L ✓</td><td>Washer</td><td>M3154</td></tr> <tr> <td>6</td><td>AN960JD8 ✓</td><td>Washer</td><td>M9636</td></tr> <tr> <td>2</td><td>MS20392-2C17</td><td>Pin</td><td>M11735</td></tr> <tr> <td>2</td><td>MS20392-2C9 ✓</td><td>Pin</td><td>M11784</td></tr> <tr> <td>2</td><td>MS20392-3C21 ✓</td><td>Pin</td><td>M11765</td></tr> <tr> <td>2</td><td>MS20995-C20 ✓</td><td>Lockwire</td><td>N/A FOR THIS ITEM</td></tr> <tr> <td>6</td><td>MS21042L08 ✓</td><td>Nut (or -8)</td><td>12790</td></tr> <tr> <td>6</td><td>MS24665-151 ✓</td><td>Cotter Pin</td><td>M11735</td></tr> <tr> <td>6</td><td>MS24694-S5 ✓</td><td>Screw</td><td>M11735</td></tr> <tr> <td>2</td><td>MS35275-233 ✓</td><td>Screw</td><td>M11822</td></tr> <tr> <td>2</td><td>MS35649-264 ✓</td><td>Nut</td><td>M11822</td></tr> <tr> <td>2</td><td>MS35650-3252 ✓</td><td>Nut</td><td>M11735</td></tr> <tr> <td>2</td><td>MS51859-7 ✓</td><td>Washer</td><td>M11822</td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3122-1 ✓	Lever	M10536-17	2	D3123-1 ✓	Cam	M10536-17	1	D3124-1 ✓	Hook	M10536-17	1	D3124-2 ✓	Hook	M10536-17	1	D3127-1 ✓	Spacer	B17784	1	D3132-041 ✓	Rod Weldment	M10536-17	1	D3133-041 ✓ 042	Rod Weldment	M10536-17	2	D3141-1 ✓	Spring	B18638	2	D3148-1 ✓	Clevis	M10536-17	1	D3155-041 ✓	Bracket Assembly	M10536-17	1	D3155-042 ✓	Bracket Assembly	M10536-17	4	AN960JD10L ✓	Washer	M12749	2	AN960JD416L ✓	Washer	M3154	6	AN960JD8 ✓	Washer	M9636	2	MS20392-2C17	Pin	M11735	2	MS20392-2C9 ✓	Pin	M11784	2	MS20392-3C21 ✓	Pin	M11765	2	MS20995-C20 ✓	Lockwire	N/A FOR THIS ITEM	6	MS21042L08 ✓	Nut (or -8)	12790	6	MS24665-151 ✓	Cotter Pin	M11735	6	MS24694-S5 ✓	Screw	M11735	2	MS35275-233 ✓	Screw	M11822	2	MS35649-264 ✓	Nut	M11822	2	MS35650-3252 ✓	Nut	M11735	2	MS51859-7 ✓	Washer	M11822		04-01-08		
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Step	Location	Procedure	By	Date	Qty																																																
37	CA	<p>Install MS21072-L3 Nutplate in Cover Assembly in two places, per Guard. Install Cover Assembly , Handle Weldment and Guard on the door; Install D3110-5 Handle Assembly as per Dwg D412-694.page 2.</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3110-5</td> <td>Handle Assembly</td> <td>M10536-17</td> </tr> <tr> <td>1</td> <td>D3135-041</td> <td>Handle Weldment</td> <td>B18861</td> </tr> <tr> <td>1</td> <td>D3139-1</td> <td>Guard</td> <td>B18863</td> </tr> <tr> <td>1</td> <td>D3139-3</td> <td>Guard</td> <td>B18863</td> </tr> <tr> <td>1</td> <td>D3163-041</td> <td>Cover Assembly</td> <td>M10536-17</td> </tr> <tr> <td>10</td> <td>AN525-10R6</td> <td>Screw</td> <td>M11822</td> </tr> <tr> <td>8</td> <td>AN525-10R7</td> <td>Screw</td> <td>M11822</td> </tr> <tr> <td>8</td> <td>MS20426AD3-3</td> <td>Rivet</td> <td>M1563</td> </tr> <tr> <td>4</td> <td>MS21072-L3</td> <td>Nutplate</td> <td>M11760</td> </tr> <tr> <td>4</td> <td>MS24693-S271</td> <td>Screw</td> <td>M12655</td> </tr> <tr> <td>4</td> <td>MS24694-S5</td> <td>Screw</td> <td>M11755</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3110-5	Handle Assembly	M10536-17	1	D3135-041	Handle Weldment	B18861	1	D3139-1	Guard	B18863	1	D3139-3	Guard	B18863	1	D3163-041	Cover Assembly	M10536-17	10	AN525-10R6	Screw	M11822	8	AN525-10R7	Screw	M11822	8	MS20426AD3-3	Rivet	M1563	4	MS21072-L3	Nutplate	M11760	4	MS24693-S271	Screw	M12655	4	MS24694-S5	Screw	M11755		03-11-10	1
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4	MS24693-S271	Screw	M12655																																																		
4	MS24694-S5	Screw	M11755																																																		
38	CA	<p>Install and Assemble brackets as per Dwg D412-694 page 2 and 5 (view H,J,K,L,M and Q).</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3115-1</td> <td>Bracket</td> <td>B17390</td> </tr> <tr> <td>2</td> <td>D3121-041</td> <td>Bracket Assembly</td> <td>M10536-17</td> </tr> <tr> <td>1</td> <td>D3121-043</td> <td>Bracket Assembly</td> <td>B18869</td> </tr> <tr> <td>1</td> <td>D3121-045</td> <td>Bracket Assembly</td> <td>B18869</td> </tr> <tr> <td>1</td> <td>D3137-041</td> <td>Bracket Assembly</td> <td>B18867</td> </tr> <tr> <td>1</td> <td>D3152-041</td> <td>Bracket Assembly</td> <td>B18867</td> </tr> <tr> <td>1</td> <td>D3183-041</td> <td>Bracket Assembly</td> <td>B19002</td> </tr> <tr> <td>2</td> <td>AN525-10R6</td> <td>Screw</td> <td>M11377</td> </tr> <tr> <td>2</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M11763</td> </tr> <tr> <td>1</td> <td>MS24694-S50</td> <td>Screw</td> <td>M11735</td> </tr> <tr> <td>2</td> <td>MS27039-1-05</td> <td>Screw</td> <td>M3601</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3115-1	Bracket	B17390	2	D3121-041	Bracket Assembly	M10536-17	1	D3121-043	Bracket Assembly	B18869	1	D3121-045	Bracket Assembly	B18869	1	D3137-041	Bracket Assembly	B18867	1	D3152-041	Bracket Assembly	B18867	1	D3183-041	Bracket Assembly	B19002	2	AN525-10R6	Screw	M11377	2	AN960JD10LL	Washer	M11763	1	MS24694-S50	Screw	M11735	2	MS27039-1-05	Screw	M3601		03-10-05	1
Qty	Part Number	Description	Batch																																																		
1	D3115-1	Bracket	B17390																																																		
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1	MS24694-S50	Screw	M11735																																																		
2	MS27039-1-05	Screw	M3601																																																		
39	CA	<p>Transfer holes using (#30) drill from D3144-13 doubler to seal and open seal holes to Ø(#24) 0.152". Install seal and doubler to door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN).</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3116-9-0770</td> <td>Seal</td> <td>B17463</td> </tr> <tr> <td>1</td> <td>D3144-13</td> <td>Doubler</td> <td>M10536-17</td> </tr> <tr> <td>37</td> <td>BSP45</td> <td>Rivet</td> <td>M11821</td> </tr> <tr> <td>2</td> <td>M7885/3-4-3</td> <td>Rivet</td> <td>M11872</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3116-9-0770	Seal	B17463	1	D3144-13	Doubler	M10536-17	37	BSP45	Rivet	M11821	2	M7885/3-4-3	Rivet	M11872		03-11-10	1																												
Qty	Part Number	Description	Batch																																																		
1	D3116-9-0770	Seal	B17463																																																		
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2	M7885/3-4-3	Rivet	M11872																																																		

CHECK ON D 3144-13 ONE HOLE MISSING

PRELIMINARY
ISSUE ✓

Step 38 : Make plate to fix D3183-041

6061T-6 - 2" x 2.160 BATCH M3932 + ALODINE
change screw by MS 24694-\$54- QTY 3 BATCH M9599

BY	DATE	AM
MWL	03-12-14	1
MWL	03-12-14	1

Make plate to fix D3137-041

6061T-6 - 2" x 2.20" BATCH M3932 + ALODINE
change Screw by MS 24694-\$54- QTY 3 BATCH M9599

ADD THESE PARTS TO THE FRONT



FT



DART AEROSPACE LTD

Work Order:

Description: Door Assembly

Part Number:

D412-694-01

D412-694-03

Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B

Qty:

Page 5 of 8

Step	Location	Procedure	By	Date	Qty																																												
40 H	CA	Install D3126 Brackets and D3138 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN). Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>x 1</td> <td>D3126-1</td> <td>Bracket</td> <td>B18656B</td> </tr> <tr> <td>x 1</td> <td>D3126-3</td> <td>Bracket</td> <td>B18657</td> </tr> <tr> <td>x 5</td> <td>D3126-5</td> <td>Bracket</td> <td>B18658H</td> </tr> <tr> <td>x 1</td> <td>D3138-1</td> <td>Cover M12715</td> <td>B174578</td> </tr> <tr> <td>x 14</td> <td>AN960JD10L</td> <td>Washer</td> <td>M12749</td> </tr> <tr> <td>x 13</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M11763</td> </tr> <tr> <td>x 14</td> <td>MS27039-1-06</td> <td>Screw</td> <td>M11754</td> </tr> <tr> <td>x 13</td> <td>MS27039-1-08</td> <td>Screw</td> <td>M13356</td> </tr> <tr> <td>x 7</td> <td>NAS43DD3-10</td> <td>Spacer</td> <td>M11764</td> </tr> <tr> <td>x 6</td> <td>NAS43DD3-14</td> <td>Spacer</td> <td>M11785</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	x 1	D3126-1	Bracket	B18656B	x 1	D3126-3	Bracket	B18657	x 5	D3126-5	Bracket	B18658H	x 1	D3138-1	Cover M12715	B174578	x 14	AN960JD10L	Washer	M12749	x 13	AN960JD10LL	Washer	M11763	x 14	MS27039-1-06	Screw	M11754	x 13	MS27039-1-08	Screw	M13356	x 7	NAS43DD3-10	Spacer	M11764	x 6	NAS43DD3-14	Spacer	M11785		03-11-28	1
Qty	Part Number	Description	Batch																																														
x 1	D3126-1	Bracket	B18656B																																														
x 1	D3126-3	Bracket	B18657																																														
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x 1	D3138-1	Cover M12715	B174578																																														
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x 13	MS27039-1-08	Screw	M13356																																														
x 7	NAS43DD3-10	Spacer	M11764																																														
x 6	NAS43DD3-14	Spacer	M11785																																														
41	CA	D412-694-03 Installation Install brackets as per Dwg D412-694 page 5 (view W) and (section LL-LL). <i>INSTALL WITH SEAL</i> Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>x 43</td> <td>D3159-041</td> <td>Bracket Assembly</td> <td>A18641</td> </tr> <tr> <td>x 1</td> <td>D3159-043</td> <td>Bracket Assembly</td> <td>B17412C</td> </tr> <tr> <td>x 1</td> <td>M7885/3-4-45</td> <td>Rivet</td> <td>M1108</td> </tr> <tr> <td>x 2</td> <td>M7885/3-4-4</td> <td>Rivet</td> <td>M9163</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	x 43	D3159-041	Bracket Assembly	A18641	x 1	D3159-043	Bracket Assembly	B17412C	x 1	M7885/3-4-45	Rivet	M1108	x 2	M7885/3-4-4	Rivet	M9163		03-11-17	1																								
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x 1	M7885/3-4-45	Rivet	M1108																																														
x 2	M7885/3-4-4	Rivet	M9163																																														
42 C	CA	Install Doublers. Cut slot openings to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ) Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>x 12</td> <td>B546</td> <td>Rivet</td> <td>M12330</td> </tr> <tr> <td>x 2</td> <td>B548</td> <td>Rivet</td> <td>M12330</td> </tr> <tr> <td>1</td> <td>D3116-5-0680</td> <td>Seal</td> <td>B17304</td> </tr> <tr> <td>1</td> <td>D3144-1</td> <td>Doubler</td> <td>B18816</td> </tr> <tr> <td>1</td> <td>D3144-5105</td> <td>Doubler M10090</td> <td>B18816</td> </tr> <tr> <td>1</td> <td>D3144-7107</td> <td>Doubler M10090</td> <td>B18816</td> </tr> <tr> <td>1</td> <td>BSP45</td> <td>Rivet</td> <td>M11821</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	x 12	B546	Rivet	M12330	x 2	B548	Rivet	M12330	1	D3116-5-0680	Seal	B17304	1	D3144-1	Doubler	B18816	1	D3144-5105	Doubler M10090	B18816	1	D3144-7107	Doubler M10090	B18816	1	BSP45	Rivet	M11821		03-11-17	1												
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1	D3144-7107	Doubler M10090	B18816																																														
1	BSP45	Rivet	M11821																																														
43	CA	Install D3150-1 Guide to Door as per Dwg D412-694 page 5 (view DD & CC) Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>x 2</td> <td>D3128-1</td> <td>Shim</td> <td>B18643</td> </tr> <tr> <td>x 2</td> <td>D3149-1</td> <td>Striker Plate</td> <td>M1053617</td> </tr> <tr> <td>x 2</td> <td>D3150-1</td> <td>Guide</td> <td>M1053617</td> </tr> <tr> <td>x 4</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M11763</td> </tr> <tr> <td>x 4</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M11493</td> </tr> <tr> <td>x 4</td> <td>MS24694-S54</td> <td>Screw</td> <td>M9599</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	x 2	D3128-1	Shim	B18643	x 2	D3149-1	Striker Plate	M1053617	x 2	D3150-1	Guide	M1053617	x 4	AN960JD10LL	Washer	M11763	x 4	MS21042L3	Nut (or -3)	M11493	x 4	MS24694-S54	Screw	M9599		03-11-17	1																
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x 4	MS24694-S54	Screw	M9599																																														
44	QC5	Inspect work to Step 43		03-12-18	1																																												
45	CA	Install D3112-1 Guide. Allow D3112-1 to move freely for adjustment per Dwg D412-694 page 5 (section X-X; Y-Y; AA-AA). Pick: <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>x 2</td> <td>D3112-1</td> <td>Guide</td> <td>B18427</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	x 2	D3112-1	Guide	B18427		03-11-15	1																																				
Qty	Part Number	Description	Batch																																														
x 2	D3112-1	Guide	B18427																																														

MADE 1 plate 0.740 x 1.650

S05A BAR M 9674 / thickness .125

For fit with hole on cover

operator mistake ml

PRELIMINARY
ISSUEStep 42: Made D3144-7102
D3144-5105
go to paint cell for Powder coat black

Ap	Location	Procedure	By	Date	Qty
42A	FP	Chemical conversion coat D3144-111/-109/-107/-105	MM	03.10.29	4
42B	FP	Powder Coat black Sandtex (4.3.5.7) as per QSI 005 4.3 D3144-111/-109/-107/-105	MM	03.10.29	4
42C	QC3	Inspect work to step 42B	RT	03.10.29	4
40A	GA	Cut (2) blanks 4.00" x 78.00" as per Dwg D3138. Grain along 78.00" Material: 5052-H34 (QQ-A-250/), 0.032" thick (M5052H34S.032)	RT	03.11.25	2
		Identify (1) for D3138-1 (1) for D3138-2		Batch: M12715	
40B	GA	Deburr	RT	03.11.25	2
40C	GA	Form as per Dwg D3138 (1) for D3138-1 (1) for D3138-2 Identify properly	SB	03/11/27	2
40D	QC5	Inspect work to step 40C	AB	03.11.27	2
40E	FP	Chemical conversion coat per QSI 005 4.1	MM	03.11.27	2
40F	FP	Powder Coat Grey Sandtex (Ref. 4.3.5.6) per QSI 005 4.3	MM	03.11.27	2
40G	QC3	Inspect powder Coat	(P)	03.11.28	2

RT

DART AEROSPACE LTD	Work Order:	
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	Qty:	Page 6 of 8

PRELIMINARY ISSUE

DART AEROSPACE LTD	Work Order:	
Description: Door Assembly	Part Number:	D412-694-01 D412-694-03
Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	Qty:	Page 7 of 8

Step	Location	Procedure	By	Date	Qty																																				
49	CA	<p>Drill # 19, C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960JD8</td> <td>Washer</td> <td>m 9636</td> </tr> <tr> <td>2</td> <td>MS21042L08</td> <td>Nut (or -8)</td> <td>m 13935</td> </tr> <tr> <td>2</td> <td>MS24694-S#51</td> <td>Screw</td> <td>m 9970</td> </tr> <tr> <td>2</td> <td>MS25281-R6</td> <td>Clamp</td> <td>m 11759</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	AN960JD8	Washer	m 9636	2	MS21042L08	Nut (or -8)	m 13935	2	MS24694-S#51	Screw	m 9970	2	MS25281-R6	Clamp	m 11759		03-11-21	1																
Qty	Part Number	Description	Batch																																						
2	AN960JD8	Washer	m 9636																																						
2	MS21042L08	Nut (or -8)	m 13935																																						
2	MS24694-S#51	Screw	m 9970																																						
2	MS25281-R6	Clamp	m 11759																																						
50	QC5	Inspect work to Step 49	RF	03-12-18	1																																				
51	CA	<p>Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM)</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3113-1</td> <td>Spring</td> <td>B 174.37</td> </tr> <tr> <td>1</td> <td>D3114-1</td> <td>Pivot</td> <td>B 18630</td> </tr> <tr> <td>1</td> <td>D3145-1</td> <td>Bracket</td> <td>B 18901B</td> </tr> <tr> <td>1</td> <td>D3146-1</td> <td>Bracket</td> <td>M 10536-17</td> </tr> <tr> <td>6</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M 11763</td> </tr> <tr> <td>6</td> <td>MS27039-1-08</td> <td>Screw</td> <td>M 13356</td> </tr> <tr> <td>A/R</td> <td>14400-1/2</td> <td>Sealant</td> <td></td> </tr> <tr> <td>A/R</td> <td>732 RTV Clear</td> <td>Expiry Date:</td> <td></td> </tr> </tbody> </table> <p>N/A FOR THIS TIME</p>	Qty	Part Number	Description	Batch	1	D3113-1	Spring	B 174.37	1	D3114-1	Pivot	B 18630	1	D3145-1	Bracket	B 18901B	1	D3146-1	Bracket	M 10536-17	6	AN960JD10LL	Washer	M 11763	6	MS27039-1-08	Screw	M 13356	A/R	14400-1/2	Sealant		A/R	732 RTV Clear	Expiry Date:			03-11-26	1
Qty	Part Number	Description	Batch																																						
1	D3113-1	Spring	B 174.37																																						
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1	D3145-1	Bracket	B 18901B																																						
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6	MS27039-1-08	Screw	M 13356																																						
A/R	14400-1/2	Sealant																																							
A/R	732 RTV Clear	Expiry Date:																																							
52	CA	<p>Install Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3116-11-0180</td> <td>Seal</td> <td>B 17441</td> </tr> <tr> <td>1</td> <td>D3120-1</td> <td>Cover</td> <td>M 10536-17</td> </tr> <tr> <td>1</td> <td>D3120-3</td> <td>Cover</td> <td>M 10536-17</td> </tr> <tr> <td>10</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M 11763</td> </tr> <tr> <td>10</td> <td>MS27039-1-06</td> <td>Screw</td> <td>M 11754</td> </tr> <tr> <td>A/R</td> <td>732 RTV Clear</td> <td>Sealant</td> <td>M 11953</td> </tr> <tr> <td></td> <td></td> <td>Expiry Date:</td> <td>July 2004</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3116-11-0180	Seal	B 17441	1	D3120-1	Cover	M 10536-17	1	D3120-3	Cover	M 10536-17	10	AN960JD10LL	Washer	M 11763	10	MS27039-1-06	Screw	M 11754	A/R	732 RTV Clear	Sealant	M 11953			Expiry Date:	July 2004		03-11-26	1				
Qty	Part Number	Description	Batch																																						
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A/R	732 RTV Clear	Sealant	M 11953																																						
		Expiry Date:	July 2004																																						
53	GA	<p>Install D3142-041 Window Mod to the Door as per Dwg D412-694 page 3</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3142-041</td> <td>Window Mod</td> <td></td> </tr> <tr> <td>72</td> <td>AN960JD4</td> <td>Washer</td> <td></td> </tr> <tr> <td>72</td> <td>MS20600AD4W5</td> <td>Rivet</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3142-041	Window Mod		72	AN960JD4	Washer		72	MS20600AD4W5	Rivet			N/A	04-01-08																				
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1	D3142-041	Window Mod																																							
72	AN960JD4	Washer																																							
72	MS20600AD4W5	Rivet																																							
53A	CA	<p>D2126-0730 seal</p> <p>Cut D3241-1 window as per template (24.50 x 13.50) D3241-1T1 Material: M-ACRYLIC-S-125 (1/8" ACRYLIC SHEET) Batch: M14111</p>		B 19210																																					
53B	CA	Deburr			03-12-16																																				

PRELIMINARY ISSUE

RF 03.12.16
RF 03.12.16

DART AEROSPACE LTD

Work Order:

Description: Door Assembly

Part Number:

D412-694-01

D412-694-03

Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B

Qty:

Page 8 of 8

Step	Location	Procedure	By	Date	Qty																																																
54	CA	<p>Install D3119-041 Cover by transfer drill from Door to Cover. Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.</p> <p>Pick: 2 MS24693 C48 SCREW</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3110-1</td> <td>Escutcheon</td> <td>B17570</td> </tr> <tr> <td>1</td> <td>D3110-3</td> <td>Handle</td> <td>B17293</td> </tr> <tr> <td>1</td> <td>D3119-041</td> <td>Cover Assembly</td> <td>B19301</td> </tr> <tr> <td>1</td> <td>D3154-1</td> <td>Key</td> <td>B M 10536-17</td> </tr> <tr> <td>1</td> <td>AN960JD10LL</td> <td>Washer</td> <td>M 11763</td> </tr> <tr> <td>1</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>N 2937</td> </tr> <tr> <td>2</td> <td>MS24693-S54</td> <td>Screw</td> <td>M 11755</td> </tr> <tr> <td>3</td> <td>MS51859-7</td> <td>Washer</td> <td>M 11822</td> </tr> <tr> <td>16</td> <td>NAS388-6-8P</td> <td>Screw</td> <td>M 11819</td> </tr> <tr> <td>16</td> <td>NAS391B6P</td> <td>Washer</td> <td>M 11761</td> </tr> <tr> <td>10</td> <td>AL S4-639-80 THIN WALL INSERT</td> <td></td> <td>M 13869</td> </tr> </tbody> </table> <p>+ add Note on step P19</p>	Qty	Part Number	Description	Batch	1	D3110-1	Escutcheon	B17570	1	D3110-3	Handle	B17293	1	D3119-041	Cover Assembly	B19301	1	D3154-1	Key	B M 10536-17	1	AN960JD10LL	Washer	M 11763	1	MS21042L3	Nut (or -3)	N 2937	2	MS24693-S54	Screw	M 11755	3	MS51859-7	Washer	M 11822	16	NAS388-6-8P	Screw	M 11819	16	NAS391B6P	Washer	M 11761	10	AL S4-639-80 THIN WALL INSERT		M 13869		03-11-24	1
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55	QC5	Inspect for 100% completeness on the W/O	RF	03.12.18	1																																																
56	KP	<p>Pick: Packing Kit</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3090-1</td> <td>Shim</td> <td>B 18037</td> </tr> <tr> <td>2</td> <td>D3090-3</td> <td>Shim</td> <td>B 18040</td> </tr> <tr> <td>1</td> <td>D3108-1</td> <td>Decal</td> <td>B 18615</td> </tr> <tr> <td>1</td> <td>D3108-2</td> <td>Decal</td> <td>B 18626</td> </tr> <tr> <td>2</td> <td>D3108-3</td> <td>Decal</td> <td>B 17204</td> </tr> <tr> <td>2</td> <td>D3108-5</td> <td>Decal</td> <td>B 17032</td> </tr> <tr> <td>1</td> <td>D3108-7</td> <td>Decal</td> <td>B 18163</td> </tr> <tr> <td>1</td> <td>D3116-3-0500</td> <td>Seal</td> <td>B 17296</td> </tr> <tr> <td>2</td> <td>D3118-1</td> <td>Sign Assembly</td> <td>B M 10536-17</td> </tr> <tr> <td>2</td> <td>D3118-3</td> <td>Sign Assembly</td> <td>B 17773</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D3090-1	Shim	B 18037	2	D3090-3	Shim	B 18040	1	D3108-1	Decal	B 18615	1	D3108-2	Decal	B 18626	2	D3108-3	Decal	B 17204	2	D3108-5	Decal	B 17032	1	D3108-7	Decal	B 18163	1	D3116-3-0500	Seal	B 17296	2	D3118-1	Sign Assembly	B M 10536-17	2	D3118-3	Sign Assembly	B 17773	N	03.12.18	1				
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57	QC4	Inspect Kit for 100% completeness on the W/O	R	03-12-16	1																																																
58	AC	Cost / part	75% for D412-694-01 25% for D412-694-03	04-01-06	1																																																
59	DC	Close W/O Inspect Level 21		04.01.09	1																																																

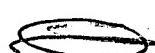
Rev	Date	Change	Revised By	Approved
A	02.08.20	New issue	KJ/RF	

PRELIMINARY
ISSUE ✓

DART AEROSPACE LTD	Work Order:	18433
Description: Door Assembly	Part Number:	D412-694-01 D412-694-03
Dwg: D3140 Rev. B	Qty:	1 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travellers for: D412-694-01-03 D3140-5/-7 Dwg not required		03.03.10	1
2	PG	Issue P/O: <u>2005241</u> Description: D3140-05-07 Doors Supplier: Delastek Ship to Delastek Qty Part Number Description Batch 1 D3140-5-7 Doubler Kits B18465B	U	03-06-05	1
3	RG	Receive	Q	03-03-10	1
4		Inspect	B	03-03-10	1

PART NUMBER: 18433
ISSUE



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 13, 2002
04:01 pm

Work Order No : 0018433S
 Project Name : D412-694-03
 Project For : wk 48
 Work Order Type : Main
 Main WO Number :
 House Part Number : D412-694-03
 Description : Door Assembly
 Manufactured : Yes
 Amount Req'd : 1
 Amount Done : 0
 Start Date :
 Est Finish Date : 11-29-02
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
HawkesburyNov 13, 2002
04:09 pm

Work Order No : 0018433
 Project Name : D412-694-01
 Project For : wk 48
 Work Order Type : Main
 Main WO Number :
 House Part Number : D412-694-01
 Description : Door Assembly
 Manufactured : Yes
 Amount Req'd : 1
 Amount Done : 0
 Start Date :
 Est Finish Date : 11-29-02
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00	0.00	0.00
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00	0.00	0.00
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DELASTEK inc.
www.delastek.com

Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice #	9088
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawsbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawsbury, Ontario K6A 1K7
Canada

Ship via		F.O.B.	Terms		Salesperson
		Origin	Net 30 days USA		Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
21/02/03	05/04/02	1064	Linda Lacelle	2004397	
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	U de M : Each
4	3	✓ 1	DKA359-0007	D412-694-011 Space Door Kit Référence DKC135-0003	Qté 1
				No. lot 4970	
				D3140 05/06/07/08 only as your REQUEST	
				<i>R. L. 03 02 24</i>	
				<i>D.S.</i>	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Cust.

Adm.

Quality

Ship.

Accepted by:

M. Janke
Quality department
AQ-357



DELASTEK

www.delastek.com

Delastek Inc.
2699 Sc avenue
Local 14, Pote - A.
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

Telephone: (819) 533-5788
Warehouse: MAIN

BILL TO:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawbsury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice #	9088
Customer #	DART US

SHIP TO:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawbsury, Ontario K6A 1K7
Canada

Ship via	F.O.B.		Termis	Salesperson	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	
4	3	1	DKA359-0007	D412-694-011 Space Door Kit Référence DKC135-0003 D3140-05/06/07/08 ONLY AS YOUR REQUEST No. Job 4970	U de M : Each  Qte 1

This shipment is made of P/N # D3119-041
 and D3119-042 to complete the kit
 previously shipped on February 25th.

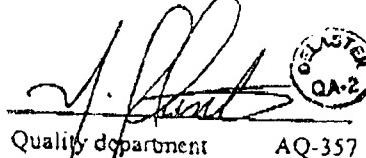
SHIP - 5- MARS - 2003
 DART AEROSPACE

X

is hereby certified that all materials, process and finished items were
 controlled and tested in accordance with the requirements of the purchase
 drawings and applicable specifications. All such records are on file at our plant
 and available for review upon request.

Cust. Adm Quality Ship.

Accepted by:


 Quality department AQ-357
 QA-2

Date Vendredi, 13/12/02 1:38:32 PM
Utilisateur Marc Dubé

Feuille de Procédé

Client	:	DK	DELASTEK (AERONAUTIQUE)	Nom Dessin	:	DOOR
Numéro Job	:	4970C		Numéro Article	:	DKC135-0008/-0009
Numéro Soumission	:	1369		Numéro Dessin	:	D3140
Numéro B.A.	:	8929		Projet Numéro	:	DKC135
Cette fois	:	13/12/02	No. B.V. :	Révision dessin	:	A
Prsht Rev.	:	NC		Matériel	:	Tissu Fibercole E-761/7788
Prem. fois	:	/ /	Type :	Date Dûe	:	16/07/02
Job précédente	:	4969C		Qté:		1 UdM: UNITE
Écrit par	:					
Vérifié & Approuvé par	:					
Commentaires	:	N° de pièce Dart Aerospace: D3140-05/-07	Générale			
		N° de pièce Delastek Aeronautique: DKA359-0008/-0009				
		N° de pièce Delastek Composites: DKC135-0008/-0009				
		Process Sheet Rév.: 00				

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	LISTE MATÉRIEL	LISTE DES MATÉRIAUX UTILISÉS
	Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs	
	LISTE DES MATÉRIAUX UTILISÉS	
		Voir séquences 2 à 15 pour la liste de matériel nécessaire à la fabrication de cette pièce.
2.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"
	Commentair Qty.: 24.50 VERGE(s)/Unit Total : 24.50 VERGE(s)	
	PREPERG FIBERCOTE E761/7781 roul. 50"	
3.0	AC0073	Tissu Blanc a Delaminer 1.5 M #3003251
	Commentair Qty.: 12.0000 METRE CAR(s)/Unit Total : 12.0000 METRE CAR(s)	
	Tissu Blanc a Delaminer 1.5 M #3003251	
4.0	AC0085	Film durisol # 3001792
	Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)	
	Film durisol # 3001792	
5.0	AC0348	Feutre drainage AB1060 ép: 6mm #sap:3001752
	Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)	
	Feutre drainage AB1060 ép: 6mm #sap:3001752	
6.0	AC0092	Sac à vide # sap 3001815
	Commentair Qty.: 23.3000 METRE CAR(s)/Unit Total : 23.3000 METRE CAR(s)	
	Sac à vide # sap 3001815	
7.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
	Commentair Qty.: 6.0000 RL(s)/Unit Total : 6.0000 RL(s)	
	Ruban à gommer jaune #: T/AT-200Y	

Date: Vendredi, 13/12/02 1:38 40 PM
 Utilisateur: Marc Dube

Feuille de Procédé

Client : DK	DELASTEK (AERONAUTIQUE)	Nom Dessin : DOOR
Numéro Job : 4970D		Numéro Article : DKC135-0010/-0011
Numéro Soumission : 1370		Numéro Dessin : D3140
Numéro B.A. : 8929		Projet Numéro : DKC135
Cette fois : 13/12/02	No. B.V. :	Révision dessin : A
Prsht Rev. : NC		Matériel : Tissu Fibercole E-761/7788
Prem. fois : / /	Type :	Date Dûe : 16/07/02
Job précédente : 4969D		Qté: 1 UdM: UNITE
Écrit par :		
Vérifié & Approuvé par :		
Commentaires :	N° de pièce Dart Aerospace: D3140-06/-08 <u>incit</u> N° de pièce Delastek Aeronautique: <u>DKA359-0010/-0011</u> N° de pièce Delastek Composites: DKC135-0010/-0011 Process Sheet Rév.: 00	

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	LISTE MATÉRIEL	LISTE DES MATÉRIAUX UTILISÉS
	Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs	
	LISTE DES MATÉRIAUX UTILISÉS	
		Voir séquences 2 à 15 pour la liste de matériel nécessaire à la fabrication de cette pièce.
2.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"
	Commentair Qty.: 24.50 VERGE(s)/Unit Total : 24.50 VERGE(s)	A8754
	PREPERG FIBERCOTE E761/7781 roul. 50" 13421	
3.0	AC0073	Tissu Blanc a Delaminer 1.5 M #3003251
	Commentair Qty.: 12.0000 METRE CAR(s)/Unit Total : 12.0000 METRE CAR(s)	
	Tissu Blanc a Delaminer 1.5 M #3003251	
4.0	AC0085	Film durisol # 3001792
	Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)	
	Film durisol # 3001792	
5.0	AC0348	Feutre drainage AB1060 ép: 6mm #sap:3001752
	Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)	
	Feutre drainage AB1060 ép: 6mm #sap:3001752	
6.0	AC0092	Sac à vide # sap 3001815
	Commentair Qty.: 23.3000 METRE CAR(s)/Unit Total : 23.3000 METRE CAR(s)	
	Sac à vide # sap 3001815	
7.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
	Commentair Qty.: 6.0000 RL(s)/Unit Total : 6.0000 RL(s)	
	Ruban à gommer jaune #: T/AT-200Y	

MATÉRIAUX Pour LA RéPARATION.

90Z hot# A2901
 Hysol 9309NA hot# 1-3144-1